

Work Order ID 86583

July-05-12 1:13:51 PM

86583

Page 1

Item ID: D2989-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 7/05/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: C2

Date: 12/07/05 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D2989	Rev D
-------	-------

100	
-----	--

100	Large Fab
-------	-----------

Large Fab	
-----------	--

Large Fab	Memo
-----------	------

Large Fab	0.00
-----------	------

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989	
--	--

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig	
---	--

cut cutouts with zip cut as per dwg D3832

3- remove from jig and weld lable plate as per dwg D2989	
--	--

A/R ER316 S.S. Rod Batch: M122130

*** PLEASE NOTE***

IE MAKING -043A

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
DSI9473

110	QC9- Inspect visual per QSI004- Fusion Welds
-----	--

110	0.00
-------	------

QC	Memo
----	------

Quality Control	0.00
-----------------	------

1x

CPL 12.12.17

DAS
23
8-89
12.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

NS2

Start Date: 7/05/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS
15
09
8-89
10 12 18

1

120

QC

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Hand Finishing

Memo

0.00

1 16 10 12 18

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run

Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg
D2989

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1⁰⁰
400°F

2⁰⁰
400°F
2³⁰

WU 23383

131

Wing Walk as per dwg QSI005 4.4 Batch 120589 0.00

0.00

Memo

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: 119943.

131

HandFinish

Hand Finishing

1 X ✓ 12/12/18

1 ✓ 12/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item Name: Basket Lid Assembly

Stop

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Start Date: 7/05/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/27/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*
140	QC3- Inspect Part Finish	0.00					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC	QC3- Inspect Part Finish Memo	0.00							1x 4 11/11/19
Quality Control									

141 Identify as per dwg & Stock Location: 358607-043 87588
141
Packaging Memo 0.00

1 8 8/12/19

150 QC21- Final Inspection - Work Order Release 0.00
150
QC Memo 0.00

13/1/9 88

NF
12-12-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

July-05-12 1:13:50 PM

Page 1

Work Order ID: 86583

Parent Item: D2989-041

Start Date: 7/05/12

Required Date: 7/27/12

Parent Item Name: Basket Lid Assembly

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM

IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC

IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC

IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10 09.14 added pressure
wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	2	2	24 5-89	12-12-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
					83907	8							
D2506 Label Plate		Manufactured	No			100	Each	12.0000	1	1	24 5-89	12-12-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
					79197	1							
					82705	11							
D2512-7 Rib		Manufactured	No			100	Each	8.0000	1	1	24 5-89	12-12-12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
					53444	0							
					77522	4							
					81048	4							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 86583

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D2581
Mounting Bracket

Manufactured No 100 Each 61.0000

2

2

DAS
24
8-83

12-12-12

392871 50

Location Loc Qty Loc Code

WA 39

82506

2

83230

3

85436

10

85452

24

WA005

22

70766

2

81253

1

82897

19

D2989-48
Rib

Manufactured No 100 Each 4.0000

2

2

DAS
24
8-83

12-12-12

B8697

Location Loc Qty Loc Code

WA 4

84604

4

D2989-49
Rib

Manufactured No 100 Each 10.0000

2

2

DAS
24
8-83

12-12-12

387650

Location Loc Qty Loc Code

WA 10

77519

4

84603

6

D3832-3
Mesh (Lid)

Manufactured No 100 Each 1.0000

1

1

DAS
24
8-83

12-12-12

B86576

Location Loc Qty Loc Code

WA035 1

77520

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 86583

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

D3833-3
Mesh (Lid End)

Manufactured No 100 Each 13.0000

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

DAS

24

8-63

12-12-12

B87412 → (1)

B87413 → (1)

DAS

24

8-63

12-12-12

B89446 → (1)

DAS

24

8-63

12-12-12

B89245 → (1)

DAS

24

8-63

12-12-12

B87906 → (1)

DAS

24

8-63

12-12-12

B87905 → (1)

D3836-041
Rib Assembly (Basket Lid, LH)

Manufactured No 100 Each 4.0000

1

1

DAS

24

8-63

12-12-12

B89446 → (1)

D3836-042
Rib Assembly (Basket Lid, RH)

Manufactured No 100 Each 4.0000

1

1

DAS

24

8-63

12-12-12

B89245 → (1)

D3852-041
Rib Assembly

Manufactured No 100 Each 6.0000

1

1

DAS

24

8-63

12-12-12

B87906 → (1)

D3852-042
Rib Assembly

Manufactured No 100 Each 5.0000

1

1

DAS

24

8-63

12-12-12

B87905 → (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

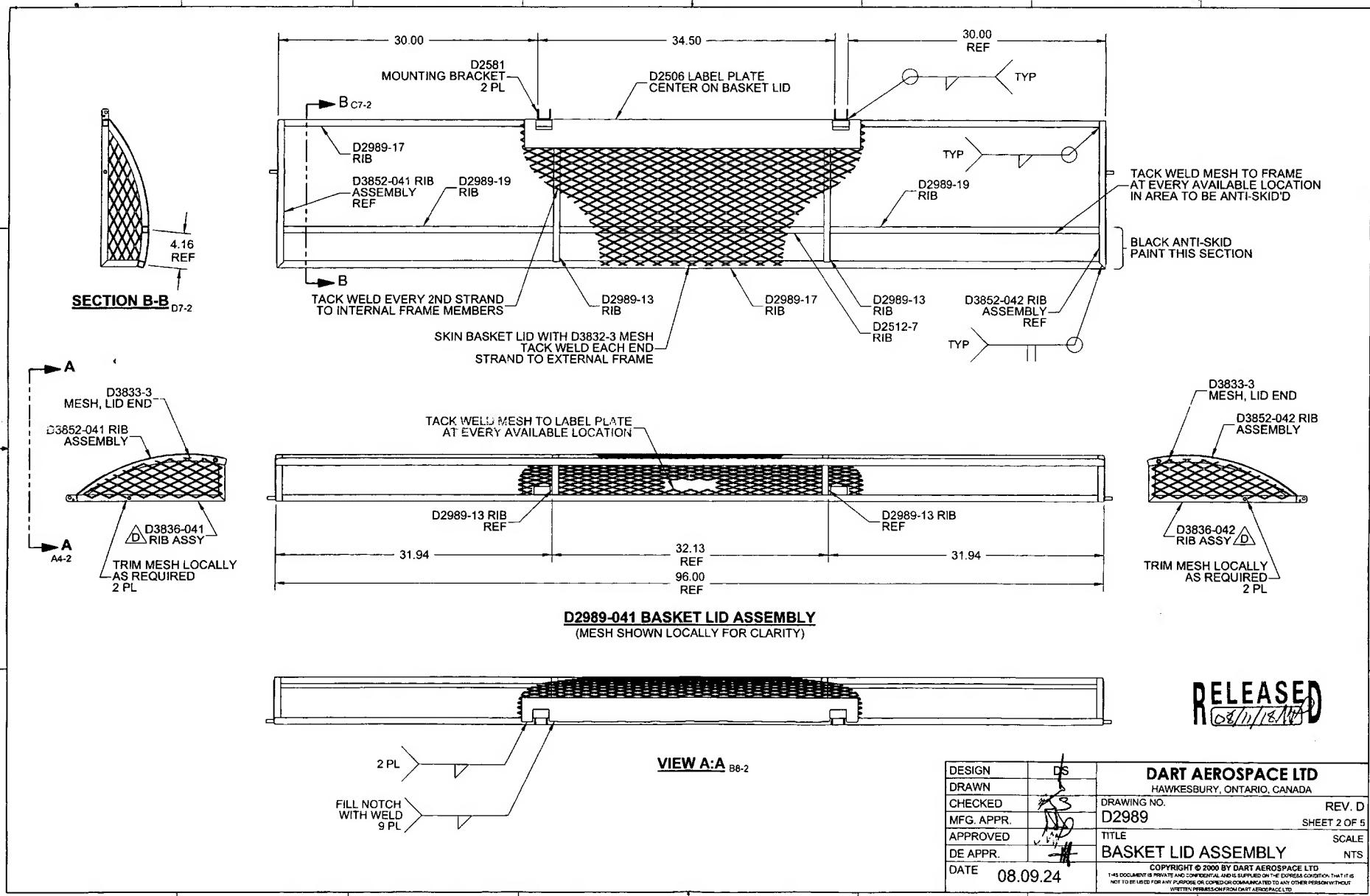
RELEASED
08/11/08 MPA

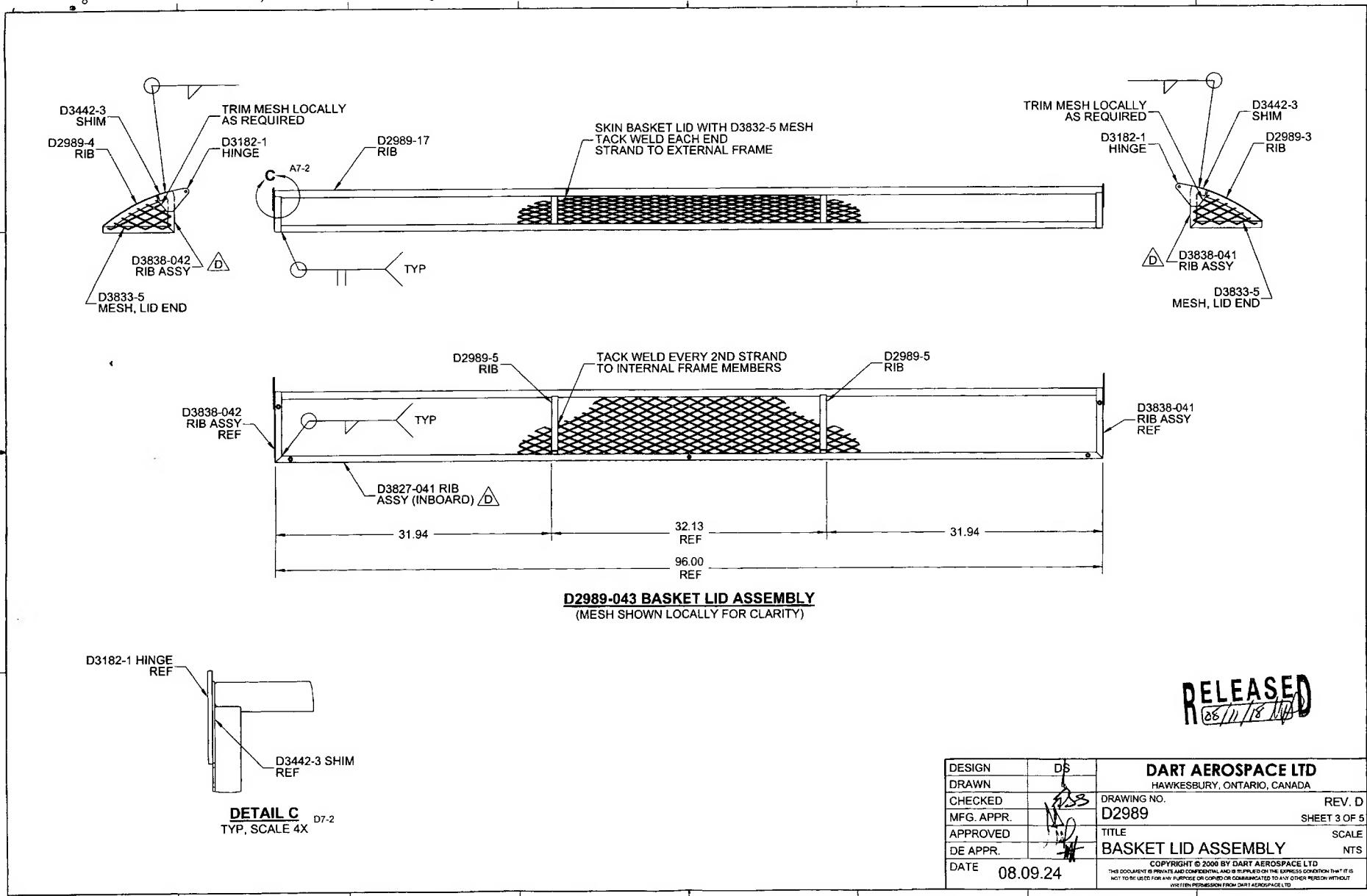
CD12107/05
W10.86583

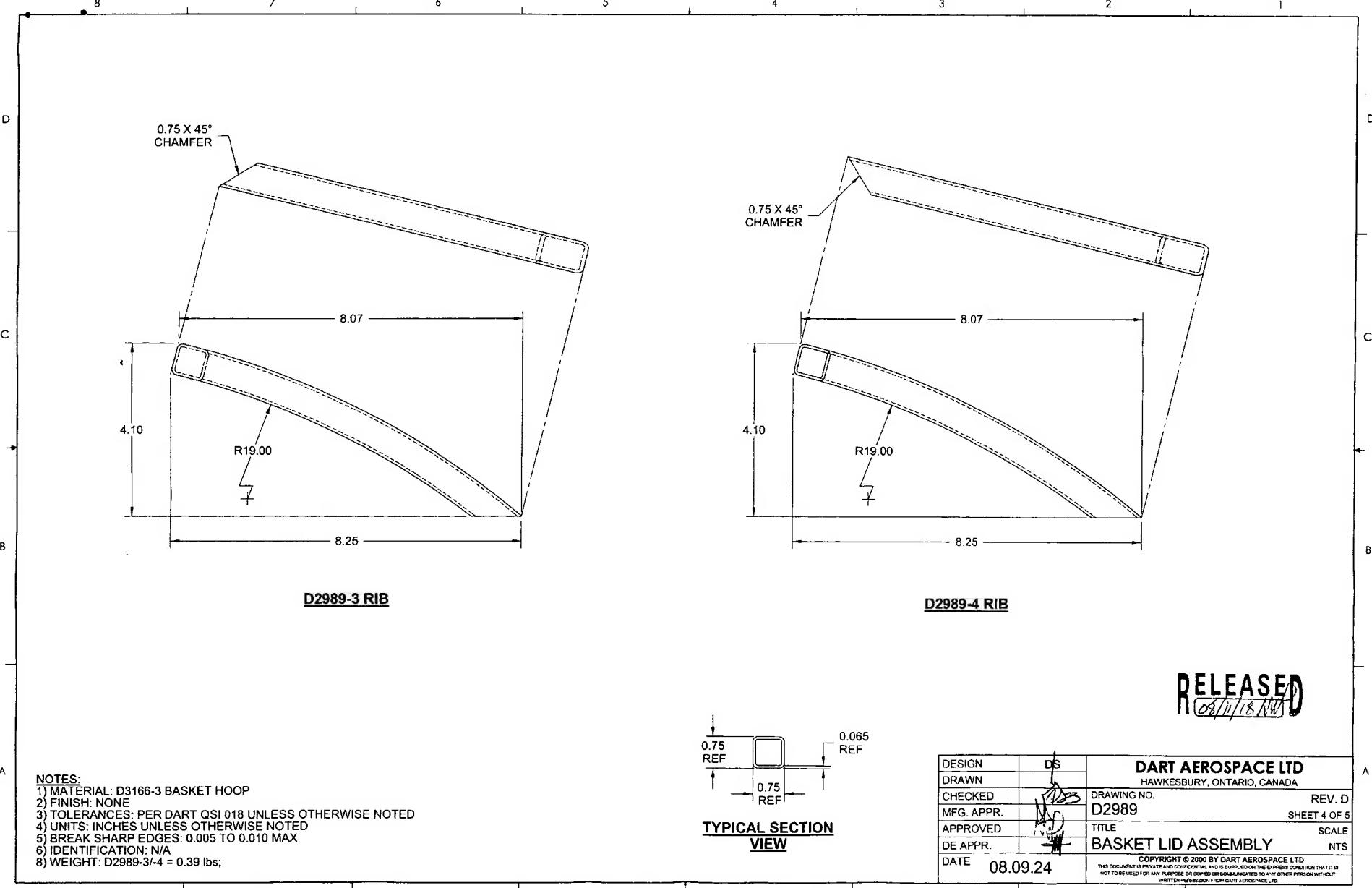
NOTES:

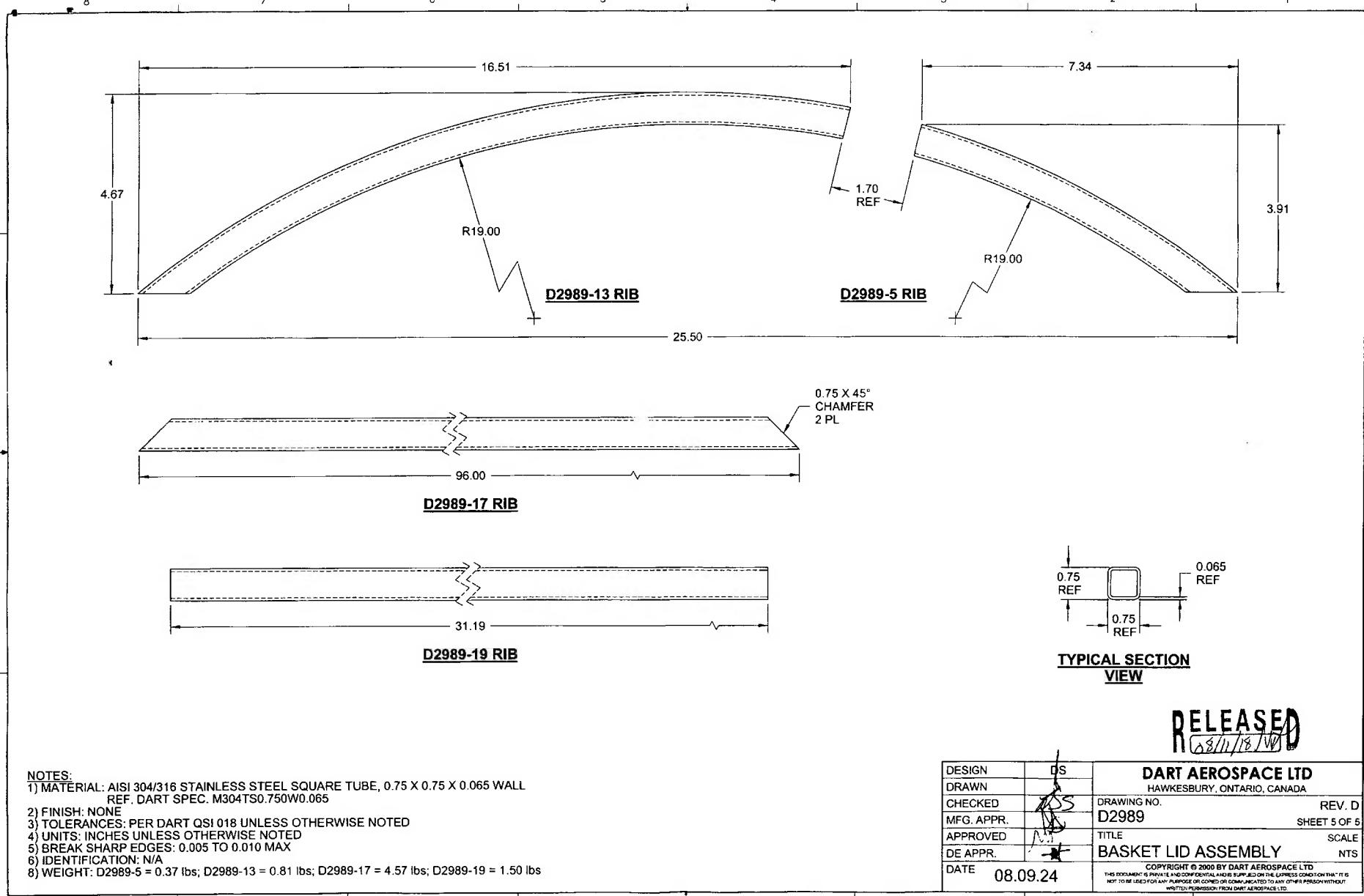
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24. D3836-041 REPLACES D2989-1/7; D3836-042 REPLACES D2989-9/10; D3833-3/5 REPLACES D2989-1/7; D3833-5 REPLACES D2989-9/10; D3832-3/5 REPLACES D2989-11; D3832-5 REPLACES D2989-11/12; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-11/12; D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-1/2-7/15 (NOW ON D3838 DWG) AND D2989-11/12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED	<i>AS</i>	D2989	SHEET 1 OF 5
MFG. APPR.	<i>MPA</i>	TITLE	SCALE
APPROVED	<i>WV</i>	BASKET LID ASSEMBLY NTS	
DE APPR.	<i>WV</i>	COPRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.09.24		









DESIGN	DS	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DS</i>	DRAWING NO.
MFG. APPR.		REV. D
APPROVED	<i>MT</i>	SHEET 5 OF 5
DE APPR.	<i>MT</i>	TITLE
DATE	08.09.24	SCALE
		BASKET LID ASSEMBLY
		NTS
		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

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(8/11/00)